

Work Order ID 70242



Page 1

Wednesday, June 01, 2011 2:49:51 PM

Item ID: DSK078

Accept



Setup Start



Revision ID:

Stop



Item Name: D2893-1 TURNING DETAIL

Start Date: 6/1/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 6/14/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: CL

Date: 11/06/01

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

DSK078

Rev A

100

0.00



MORI SEIKI CNC LATHE LARGE

Re 11.6.9

9

Doosan

Memo

0.00

Doosan Lathe

Turn blank as per Folio FA081
(4TH AXIS PLUG DT8492)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

Re 11.6.9

9

QC

Memo

0.00

Quality Control

120

0.00



QC8- Inspect parts - second check

Re 11/6/14

9

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Cust Item ID:

Required Date: 6/14/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



Packaging

R 11.6.14

1

Packaging

Memo

0.00

Packaging

Identify and Stock in Kanban Location: CNC

140

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

11/6/15

MF
11-06-14

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, June 01, 2011 2:49:49 PM

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Work Order ID: 70242

Parent Item: DSK078

Parent Item Name: D2893-1 TURNING DETAIL

Start Date: 6/1/2011

Required Date: 6/14/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP rev A. 08.03.13 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6104-005

Manufactured

No

Each

9.0000

10



29 11. 6. 9

Round Billet, 17-4

Location

MAT

Loc Qty

9

Loc Code

9

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

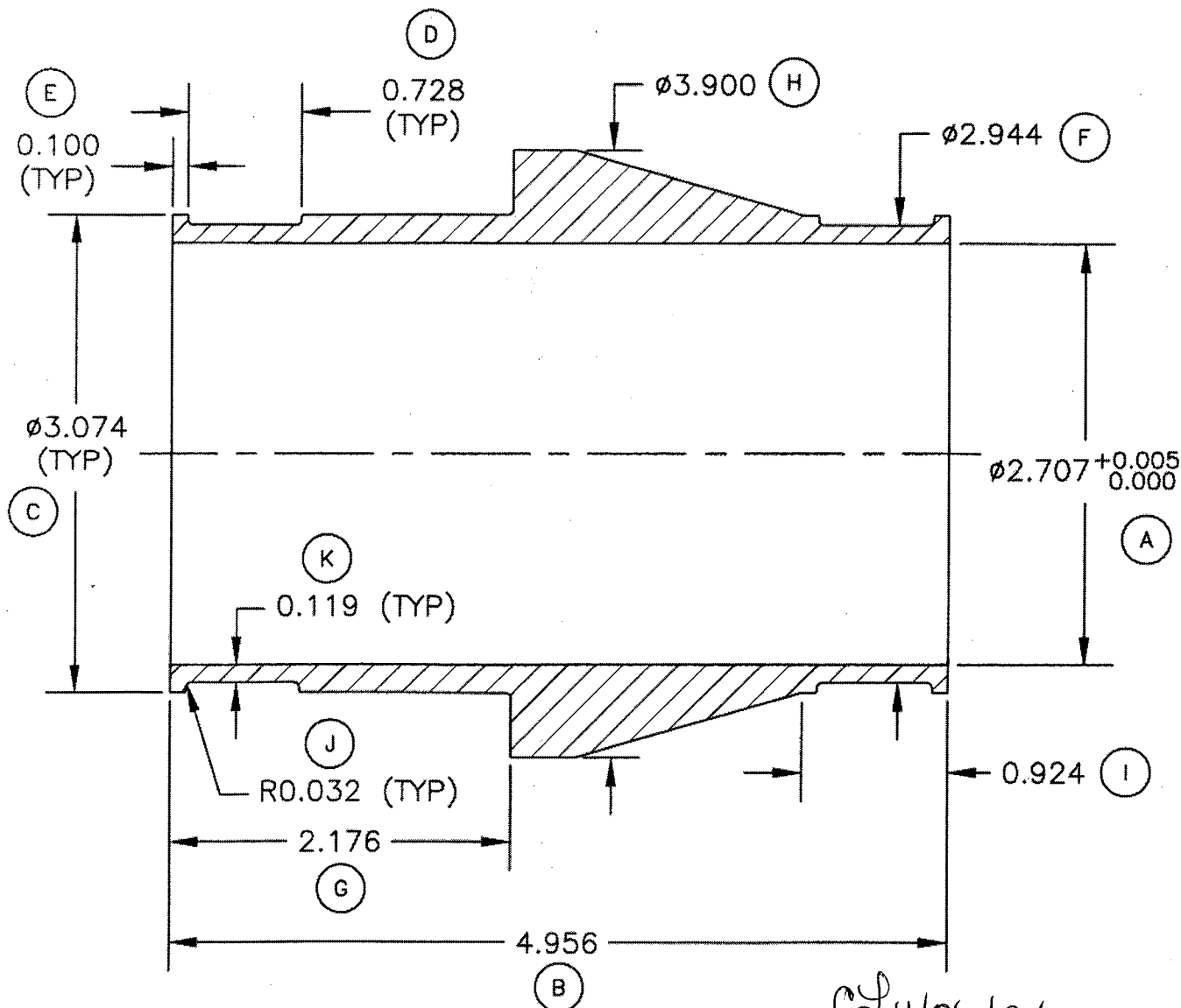
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. DSK 078	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2893-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
03.07.01

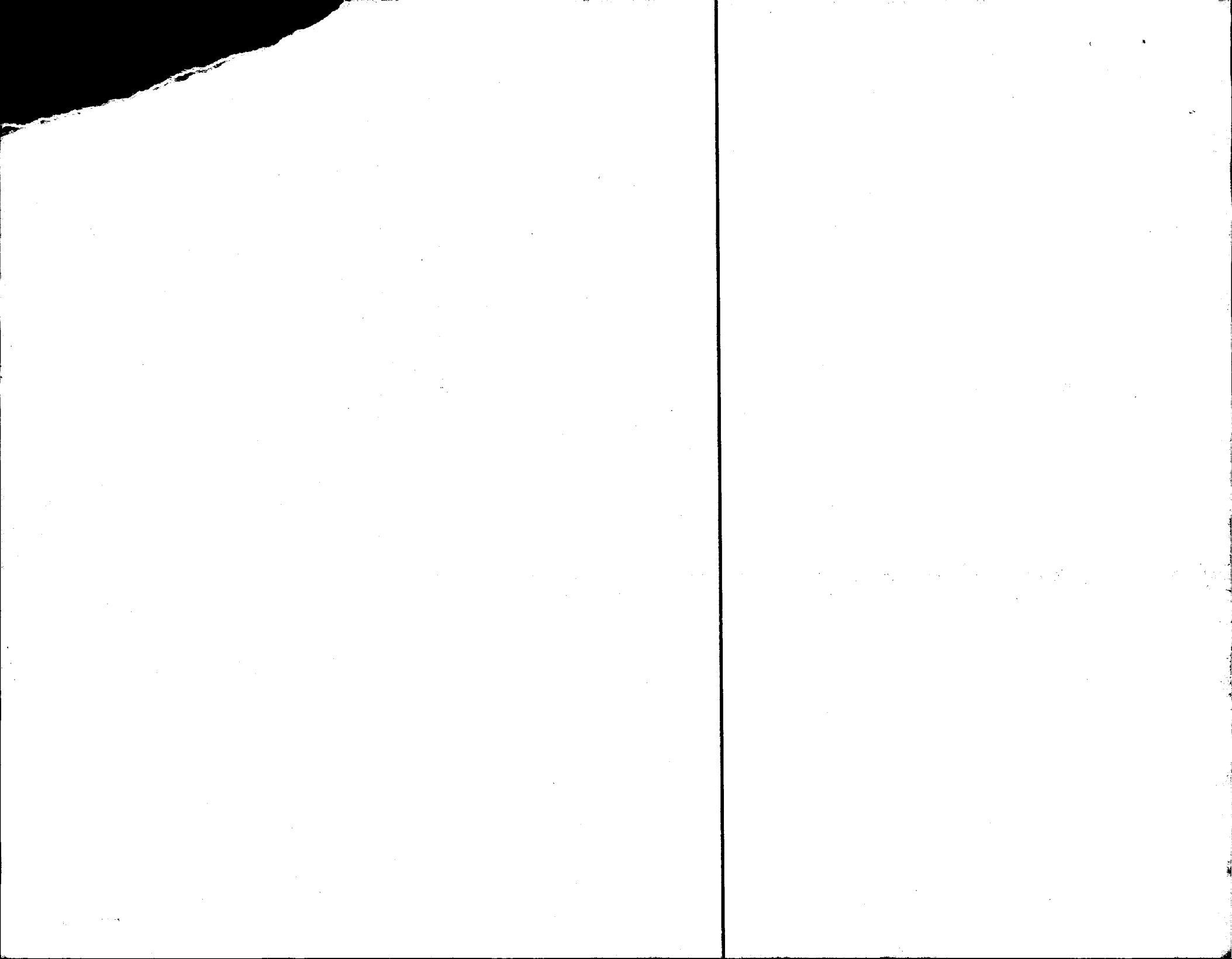


D2893-1 TURNING DETAIL

CD11106101
W10.70242

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DART AEROSPACE LTD		Work Order:	70242
Description: Turning Detail for D2893-1		Part Number:	DSK078
Inspection Dwg: DSK078	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.707	2.712	29 .02	2.709	2.709	2.709	2.709	2.709
B	4.946	4.966		4.960	4.960	4.960	4.960	4.960
C	3.064	3.084		3.076	3.076	3.076	3.076	3.076
D	0.718	0.738		.726	.726	.726	.726	.726
E	0.090	0.110		.101	.101	.101	.101	.101
F	2.934	2.954		2.947	2.947	2.947	2.947	2.947
G	2.166	2.186		2.176	2.176	2.176	2.176	2.176
H	3.890	3.910		3.903	3.903	3.903	3.903	3.903
I	0.914	0.934		.926	.926	.926	.926	.926
J	0.022	0.042		.032	.032	.032	.032	.032
K	0.109	0.129		.119	.119	.119	.119	.119
L								
M								
N								
O								
P								

Measured by: 29 Date: 11.6.9

Audited by: SA Date: 4/6/14

Prototype Approval: _____ Date: _____

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	<u>SA</u>

DART AEROSPACE LTD		Work Order:	70242
Description: Turning Detail for D2893-1		Part Number:	DSK078
Inspection Dwg: DSK078	Rev: A	Page 1 of 1	

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K	0.109	0.129		.119	.119	.119	.119	
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Measured by: 29 **Date:** 11.0.9

Audited by: 5 **Date:** 11/6/14

Prototype Approval: **Date:**

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	<u></u>

